



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3500-1

Job Sheet 184915



✓
LOAD

Part No: D3500-1

Job Qty: 40 ea

Part Name: Saddle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/18/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP Rev:A New Issue 06-06-15 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea	11/9/18	11/9/18	0.00	0.00	Start Up Machining-2		SBC 18/11/30
100	CNC Vertical Machining	40 pcs	11/9/18	11/9/18	0.15	50.00	HAAS1-3		SBC
120	QC	40 pcs	11/9/18	11/9/18	0.00	0.00	QC8		mm L 18/12/11
130	HandFinish	40 pcs	11/9/18	11/9/18	0.00	1.29	HandFinish1		SA 18/12/16
140	Powdercoat	40 pcs	11/9/18	11/9/18	0.00	1.21	Powdercoat1		DR 18/12-17
150	QC	40 pcs	11/9/18	11/9/18	0.00	0.00	QC3		38
160	Packaging	40 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3-1	3403	JAN 9-2019
170	QC21-SA	40 Ea	11/9/18	11/9/18	0.00	0.00	QC21		21 JAN 02 2019

Part Op 100 - Program Batch No. 9133673 Double check by: SL 1-Machine Step No 1 per Folio FA641 and inspect per Descriptions: attached Dimension Sheets 2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA641 and inspect p 8:35 O.U.T. 320° FINISH 4:05. M 138951.
140 - START TIME: 8:35

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6102-013	Saddle Billet	40 Ea (1 ea)	90-Start up Operation	5125528 5133669

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6102-013	40	6	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle	1.125Inches + 0.020 - 0.000	1.145 1.125	Radius	
2	Saddle	0.490Inches + 0.020 - 0.000	0.510 0.490	Radius	
3	Saddle	0.615Inches + 0.020 - 0.000	0.635 0.615		
4	Saddle	0.240Inches + 0.020 - 0.000	0.260 0.240		
5	Saddle	1.810Inches	1.830		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																									
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval																																									
Description Work Order Deviation			Disposition																																										
DART Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 813 632 - 5200 Email: sales@dartaero.com www.dartaerospace.com Date: 11/30/18 Container No: S133673 Part: D3500 - 1 Job No: 184915 Serial No/Batch: S133673 Revision: Inspector: Exp Date: Instructions: Various STC's			Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																										
<table style="width:100%; font-size: 8px;"> <tr> <th colspan="4" style="text-align: left;">Root Cause</th> <th colspan="4" style="text-align: left;">FAULT CATEGORY</th> </tr> <tr> <td style="width:15%;">Environment ☐</td> <td style="width:15%;">Design ☐</td> <td style="width:15%;">Doc/Data ☐</td> <td style="width:15%;">Equip/Tooling ☐</td> <td style="width:15%;">Handling/Pre ☐</td> <td style="width:15%;">Material ☐</td> <td style="width:15%;">Internal Transport ☐</td> <td style="width:15%;">Tribal Knowledge ☐</td> </tr> <tr> <td>LOA ☐</td> <td>Substation ☐</td> <td>Past Expiry Date ☐</td> <td>Misidentified ☐</td> <td>No Re-verf ☐</td> <td>Operator ☐</td> <td>Offset/Set ☐</td> <td>Supplier ☐</td> </tr> <tr> <td>Training ☐</td> <td>Use for Te ☐</td> <td>Poor Infor. ☐</td> <td>Rushing ☐</td> <td>Heat Treat ☐</td> <td>Wave/Twist in Tube ☐</td> <td>Marks/Chatter ☐</td> <td>OTHER : ☐</td> </tr> <tr> <td>Product Improvement ☐</td> <td>Process Improvement ☐</td> <td>Manufacturing Process ☐</td> <td>Past Due ☐</td> <td>Cut Too Short ☐</td> <td>Instructions Incomplete/Unclear ☐</td> <td>Drill Holes ☐</td> <td></td> </tr> </table>						Root Cause				FAULT CATEGORY				Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verf ☐	Operator ☐	Offset/Set ☐	Supplier ☐	Training ☐	Use for Te ☐	Poor Infor. ☐	Rushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	OTHER : ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	
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			+ 0.020	1.810	
			- 0.000		
6	Saddle	0.240Inches	+ 0.020 - 0.000	0.260 0.240	
7	Saddle	0.140Inches	+ 0.020 - 0.000	0.160 0.140	
8	Saddle	0.140Inches	+ 0.020 - 0.000	0.160 0.140	
9	Saddle	0.140Inches	+ 0.020 - 0.000	0.160 0.140	
10	Saddle	0.483Inches	+ 0.007 - 0.000	0.490 0.483	
11	Saddle	1.175Inches	+ 0.010 - 0.000	1.185 1.175	
12	Saddle	3.145Inches	+ 0.010 - 0.000	3.155 3.145	
13	Saddle	1.175Inches	+ 0.010 - 0.000	1.185 1.175	
14	Saddle	0.365Inches	+ 0.020 - 0.000	0.385 0.365	
15	Saddle	0.490Inches	+ 0.020 - 0.000	0.510 0.490	
16	Saddle	0.515Inches	+ 0.020 - 0.000	0.535 0.515	Radius
17	Saddle	1.575Inches	+ 0.020 - 0.000	1.595 1.575	Radius
18	Saddle	0.240Inches	+ 0.020 - 0.000	0.260 0.240	
19	Saddle	0.490Inches	+ 0.020 - 0.000	0.510 0.490	
20	Saddle	3.590Inches	+ 0.060 - 0.000	3.650 3.590	
21	Saddle	0.315Inches	+ 0.007 - 0.000	0.322 0.315	
22	Saddle	0.256Inches	+ 0.006 - 0.000	0.262 0.256	
23	Saddle	6.500Inches	+ 0.020 - 0.000	6.520 6.500	
24	Saddle	5.990Inches	+ 0.020 - 0.000	6.010 5.990	
25	Saddle	2.820Inches	+ 0.010 - 0.000	2.830 2.820	
26	Saddle	2.495Inches	+ 0.010 - 0.000	2.505 2.495	
27	Saddle	2.245Inches	+ 0.010 - 0.000	2.255 2.245	
28	Saddle	1.120Inches	+ 0.010 - 0.000	1.130 1.120	
29	Saddle	0.540Inches	+ 0.020 - 0.000	0.560 0.540	
30	Saddle	0.793Inches	+ 0.010 - 0.000	0.803 0.793	
31	Saddle	0.240Inches	+ 0.020 - 0.000	0.260 0.240	Radius
32	Saddle	0.040Inches	+ 0.020 - 0.000	0.060 0.040	
33	Saddle	0.100Inches	+ 0.020 - 0.000	0.120 0.100	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

DART AEROSPACE LTD				Work Order: 184 915	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.483	0.490 ✓		0.484	0.484	0.484	0.484	0.484
B	1.175	1.185 ✓		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155 ✓		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185 ✓		1.180	1.180	1.180	1.180	1.18
E	0.365	0.385 ✓		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510 ✓		0.500	0.500	0.500	0.500	0.500
H	R0.515	R0.535 ✓		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595 ✓		1.583	1.583	1.583	1.583	1.583
J	0.240	0.260		0.251	0.251	0.251	0.251	0.25
K	0.490	0.510 ✓		0.500	0.500	0.500	0.500	0.500
L	3.590	3.650 ✓		3.62	3.62	3.62	3.62	3.62
M	0.315	0.322 ✓		0.316	0.316	0.316	0.316	0.316
N	0.256	0.262 ✓		0.257	0.257	0.257	0.257	0.257
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830 ✓		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505 ✓		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255 ✓		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130 ✓		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		0.550	0.550	0.550	0.550	0.550
V	0.793	0.803 ✓		0.798	0.798	0.798	0.798	0.798
W	R.240	R.260 ✓		R0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.048	0.048	0.048	0.048	0.048
Y	0.100	0.120		0.107	0.107	0.107	0.107	0.107
AA	R1.125	R1.145 ✓		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510 ✓		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635 ✓		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.257	0.255	0.257	0.257	0.257
AE	1.810	1.830 ✓		1.820	1.820	1.820	1.820	1.820
AF	0.240	0.260		0.251	0.252	0.252	0.251	0.252
AG	0.140	0.160		0.152	0.155	0.151	0.151	0.151
AH	0.140	0.160		0.155	0.157	0.155	0.156	0.157
AI	0.140	0.160		0.151	0.152	0.151	0.152	0.152
Accept/Reject								

Measured by: VHS	Date:
Audited by: nmc	Date: 18/12/11
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 184 915	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1 6	2 7	3 8	4 9	5 10
A	0.483	0.490		0.484	0.484	0.484	0.484	0.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510		0.500	0.500	0.500	0.500	0.500
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.583	1.583	1.583	1.583	1.583
J	0.240	0.260		0.251	0.251	0.251	0.251	0.249
K	0.490	0.510		0.500	0.500	0.500	0.500	0.500
L	3.590	3.650		3.62	3.62	3.62	3.62	3.62
M	0.315	0.322		0.316	0.316	0.316	0.316	0.316
N	0.256	0.262		0.257	0.257	0.257	0.256	0.257
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		0.550	0.550	0.550	0.550	0.550
V	0.793	0.803		0.798	0.798	0.798	0.798	0.798
W	R.240	R.260		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.048	0.048	0.048	0.048	0.048
Y	0.100	0.120		0.105	0.105	0.105	0.105	0.105
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.256	0.256	0.257	0.256	0.256
AE	1.810	1.830		1.820	1.820	1.820	1.820	1.820
AF	0.240	0.260		0.252	0.253	0.252	0.252	0.252
AG	0.140	0.160		0.151	0.151	0.151	0.151	0.151
AH	0.140	0.160		0.156	0.155	0.155	0.158	0.155
AI	0.140	0.160		0.151	0.151	0.151	0.152	0.150
Accept/Reject								

Measured by: VAS	Date:
Audited by: J. M. C.	Date: 12/12/11
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 184 915	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				11	12	13	14	15
A	0.483	0.490		0.484	0.484	0.484	0.484	0.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510		0.500	0.500	0.500	0.500	0.500
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.583	1.583	1.583	1.583	1.583
J	0.240	0.260		0.251	0.249	0.249	0.247	0.247
K	0.490	0.510		0.500	0.500	0.500	0.500	0.500
L	3.590	3.650		3.62	3.62	3.62	3.62	3.62
M	0.315	0.322		0.316	0.316	0.316	0.316	0.316
N	0.256	0.262		0.257	0.257	0.257	0.257	0.257
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		0.550	0.550	0.551	0.550	0.550
V	0.793	0.803		0.798	0.798	0.798	0.798	0.798
W	R.240	R.260		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.050	0.05	0.050	0.049	0.049
Y	0.100	0.120		0.108	0.108	0.105	0.106	0.106
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.256	0.255	0.255	0.255	0.254
AE	1.810	1.830		1.820	1.820	1.820	1.820	1.820
AF	0.240	0.260		0.252	0.251	0.253	0.252	0.252
AG	0.140	0.160		0.151	0.151	0.151	0.151	0.151
AH	0.140	0.160		0.155	0.155	0.156	0.155	0.155
AI	0.140	0.160		0.151	0.150	0.152	0.153	0.151
Accept/Reject								

Measured by: UH2	Date:
Audited by: mmL	Date: 12/12/11
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD		Work Order: 184 915
Description: Saddle		Part Number: D3500-1
Inspection Dwg: D3500 Rev: C DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	#16	#17	#18	#19	#20
A	0.483	0.490		0.484	0.484	0.484	0.484	0.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510		0.500	0.500	0.500	0.500	0.500
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.583	1.583	1.583	1.583	1.583
J	0.240	0.260		0.247	0.250	0.247	0.247	0.248
K	0.490	0.510		0.500	0.500	0.500	0.500	0.500
L	3.590	3.650		3.62	3.62	3.62	3.62	3.62
M	0.315	0.322		0.316	0.316	0.316	0.316	0.316
N	0.256	0.262		0.257	0.257	0.257	0.257	0.257
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		0.550	0.550	0.550	0.550	0.550
V	0.793	0.803		0.798	0.798	0.798	0.798	0.798
W	R.240	R.260		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.050	0.050	0.050	0.050	0.050
Y	0.100	0.120		0.106	0.106	0.106	0.106	0.106
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.255	0.255	0.255	0.255	0.255
AE	1.810	1.830		1.820	1.820	1.820	1.820	1.820
AF	0.240	0.260		0.252	0.252	0.252	0.253	0.252
AG	0.140	0.160		0.151	0.151	0.151	0.151	0.151
AH	0.140	0.160		0.154	0.155	0.156	0.155	0.155
AI	0.140	0.160		0.149	0.149	0.152	0.150	0.151
Accept/Reject								

Measured by: <i>VH</i>	Date:
Audited by: <i>mmk</i>	Date: 18/12/11
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	<i>[Signature]</i>

DART AEROSPACE LTD				Work Order: 184 915	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				21	22	23	24	25
A	0.483	0.490		0.484	0.484	0.484	0.484	0.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510		0.500	0.500	0.500	0.500	0.500
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.583	1.583	1.583	1.583	1.583
J	0.240	0.260		0.247	0.247	0.248	0.247	0.247
K	0.490	0.510		0.500	0.500	0.500	0.500	0.500
L	3.590	3.650		3.62	3.62	3.62	3.62	3.62
M	0.315	0.322		0.316	0.316	0.316	0.316	0.316
N	0.256	0.262		0.257	0.257	0.257	0.257	0.257
O	6.500	6.520		6.510	6.510	6.510	6.510	6.510
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		0.550	0.550	0.550	0.550	0.550
V	0.793	0.803		0.798	0.798	0.798	0.798	0.798
W	R.240	R.260		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.050	0.050	0.050	0.050	0.050
Y	0.100	0.120		0.105	0.105	0.107	0.106	0.106
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.254	0.255	0.254	0.255	0.255
AE	1.810	1.830		1.820	1.820	1.820	1.820	1.820
AF	0.240	0.260		0.252	0.252	0.251	0.252	0.252
AG	0.140	0.160		0.151	0.151	0.151	0.150	0.150
AH	0.140	0.160		0.155	0.155	0.154	0.154	0.153
AI	0.140	0.160		0.152	0.152	0.153	0.150	0.151

Accept/Reject

Measured by: [Signature]	Date:
Audited by: [Signature]	Date: 18/12/11
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ [Signature]	[Signature]

DART AEROSPACE LTD				Work Order: 184 915	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				26 1	27 2	28 3	29 4	30 5
A	0.483	0.490		0.484	0.484	0.484	0.484	0.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		0.375	0.375	0.375	0.375	0.375
F	0.490	0.510		0.500	0.500	0.499	0.500	0.500
H	R0.515	R0.535		0.525	0.525	0.525	0.525	0.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.583	1.583	1.583	1.583	1.583
J	0.240	0.260		0.248	0.249	0.248	0.249	0.249
K	0.490	0.510		0.500	0.500	0.500	0.500	0.500
L	3.590	3.650		3.62	3.62	3.620	3.620	3.620
M	0.315	0.322		0.316	0.316	0.316	0.316	0.316
N	0.256	0.262		0.257	0.257	0.257	0.257	0.257
O	6.500	6.520		6.508	6.508	6.508	6.508	6.509
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		0.550	0.550	0.550	0.549	0.550
V	0.793	0.803		0.798	0.798	0.798	0.798	0.798
W	R.240	R.260		0.250	0.250	0.250	0.250	0.250
X	0.040	0.060		0.050	0.045	0.048	0.048	0.050
Y	0.100	0.120		0.110	0.108	0.106	0.105	0.105
AA	R1.125	R1.145		1.135	1.135	1.135	1.135	1.135
AB	R.490	R.510		0.500	0.500	0.500	0.500	0.500
AC	0.615	0.635		0.625	0.625	0.625	0.625	0.625
AD	0.240	0.260		0.253	0.253	0.255	0.254	0.254
AE	1.810	1.830		1.820	1.820	1.820	1.820	1.820
AF	0.240	0.260		0.251	0.251	0.251	0.251	0.252
AG	0.140	0.160		0.151	0.152	0.151	0.152	0.152
AH	0.140	0.160		0.150	0.150	0.150	0.149	0.150
AI	0.140	0.160		0.148	0.149	0.148	0.148	0.148

DAS Accept/Reject

Measured by: 57	Date: 18/12/04
Audited by: 9-89 MML	Date: 18/12/11
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 184415	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				31	32	33	34	35
A	0.483	0.490		.484	.484	.484	.484	.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.375	.375	.375	.375	.375
F	0.490	0.510		.500	.500	.500	.499	.500
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.583	1.583	1.583	1.583	1.583
J	0.240	0.260		.248	.248	.248	.248	.248
K	0.490	0.510		.500	.500	.500	.499	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.257	.257	.257	.257	.257
O	6.500	6.520		6.508	6.508	6.508	6.509	6.509
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.550	.550	.550	.550	.550
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.050	.050	.050
Y	0.100	0.120		.106	.105	.107	.106	.105
AA	R1.125	R1.145		1.133	1.133	1.133	1.133	1.133
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.625	.625	.625	.625	.625
AD	0.240	0.260		.254	.254	.254	.254	.254
AE	1.810	1.830		1.820	1.820	1.820	1.820	1.820
AF	0.240	0.260		.252	.251	.251	.251	.251
AG	0.140	0.160		.152	.152	.152	.152	.152
AH	0.140	0.160		.150	.151	.150	.150	.150
AI	0.140	0.160		.149	.149	.148	.148	.148

DAS Accept/Reject

Measured by: 57	Date: 18/12/04
Audited by: 9-89 ZML	Date: 15/12/11
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	

DART AEROSPACE LTD				Work Order: 184 915	
Description: Saddle				Part Number: D3500-1	
Inspection Dwg: D3500 Rev: C DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	36 ¹	37 ²	38 ³	39 ⁴	40 ⁵
A	0.483	0.490		.484	.484	.484	.484	.484
B	1.175	1.185		1.180	1.180	1.180	1.180	1.180
C	3.145	3.155		3.150	3.150	3.150	3.150	3.150
D	1.175	1.185		1.180	1.180	1.180	1.180	1.180
E	0.365	0.385		.375	.375	.375	.375	.375
F	0.490	0.510		.500	.499	.499	.500	.500
H	R0.515	R0.535		.525	.525	.525	.525	.525
(Note: Dimension I is 0.015" over flange)								
I	R1.575	R1.595		1.583	1.583	1.583	1.583	1.583
J	0.240	0.260		.248	.248	.248	.249	.248
K	0.490	0.510		.500	.499	.499	.500	.500
L	3.590	3.650		3.620	3.620	3.620	3.620	3.620
M	0.315	0.322		.316	.316	.316	.316	.316
N	0.256	0.262		.257	.257	.257	.257	.257
O	6.500	6.520		6.509	6.509	6.508	6.509	6.509
P	5.990	6.010		6.000	6.000	6.000	6.000	6.000
Q	2.820	2.830		2.825	2.825	2.825	2.825	2.825
R	2.495	2.505		2.500	2.500	2.500	2.500	2.500
S	2.245	2.255		2.250	2.250	2.250	2.250	2.250
T	1.120	1.130		1.125	1.125	1.125	1.125	1.125
U	0.540	0.560		.549	.550	.550	.550	.549
V	0.793	0.803		.798	.798	.798	.798	.798
W	R.240	R.260		.250	.250	.250	.250	.250
X	0.040	0.060		.050	.050	.050	.050	.050
Y	0.100	0.120		.106	.106	.105	.105	.106
AA	R1.125	R1.145		1.133	1.133	1.133	1.133	1.133
AB	R.490	R.510		.500	.500	.500	.500	.500
AC	0.615	0.635		.625	.625	.625	.625	.625
AD	0.240	0.260		.254	.254	.254	.254	.254
AE	1.810	1.830		1.820	1.820	1.820	1.820	1.820
AF	0.240	0.260		.252	.252	.252	.252	.252
AG	0.140	0.160		.152	.152	.152	.152	.152
AH	0.140	0.160		.150	.149	.150	.150	.150
AI	0.140	0.160		.148	.148	.148	.149	.149

DAS Accept/Reject

Measured by: 57	Date: 18/12/04
Audited by: 9-89 <i>amr</i>	Date: 18/12/11
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	
E	15.02.26	Dimension H added	KJ	